



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

4

D119-796-141TRN
Job Sheet 174927



Part No: D119-796-141TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 6/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: D119-796-141 REV H IPP REV A RQ 14/06/06 VERIFIED BY DD IPP REV:B 16.05.04 AS PER DWG REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/19/18	6/19/18	0.00	0.00	Start Up Crosstubes-1		↑
100	Mori Seiki	1 pcs	6/19/18	6/19/18	1.99	1.52	Mori Seiki TL-40		DAS
110	QC	1 pcs	6/19/18	6/19/18	0.00	0.00	QC2		56
120	Mori Seiki	1 pcs	6/19/18	6/19/18	0.00	1.52	Mori Seiki TL-40		9-89
130	QC	1 pcs	6/19/18	6/19/18	0.00	0.00	QC2		↓
140	QC	1 pcs	6/19/18	6/19/18	0.00	0.00	QC8		GP
145	Crosstubes	1 pcs	6/19/18	6/19/18	0.00	0.33	Crosstubes-1		EA 18-04-18
150	HandFXtube	1 pcs	6/20/18	6/20/18	0.00	0.40	Crosstubes-3		↓
160	QC	1 pcs	6/20/18	6/20/18	0.00	0.00	QC7-1		↓
170	Packaging	1 pcs	6/20/18	6/20/18	0.00	0.00	Packaging3-1		↓
180	QC21-FG	1 Ea	6/20/18	6/20/18	0.00	0.00	QC21		↓

Part Op 100 - 1-Fill tube with sand & install plugs on both ends as per Folio FB316 2-Turn first side as per Folio FB316 3-Blend Descriptions: transition lines only, **do not sand whole tube**: FOLIO REV: _____ DWG REV: _____ *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.
120 - 1-Turn second side as per Folio FB316 2-Blend transition lines only, **do not sand whole tube**: 3-Remove sand and plugs 4- scribe batch # and part # as per dwg
145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - 1- handfinish X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE
170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6024-103	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6024-103	1	30	0



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S060058



Part: D119-796-141TRN

Job No: 174927

Serial No/Batch: S060058

Revision: H

Inspector:

Date: 04/11/18

04/11/18
20
DART

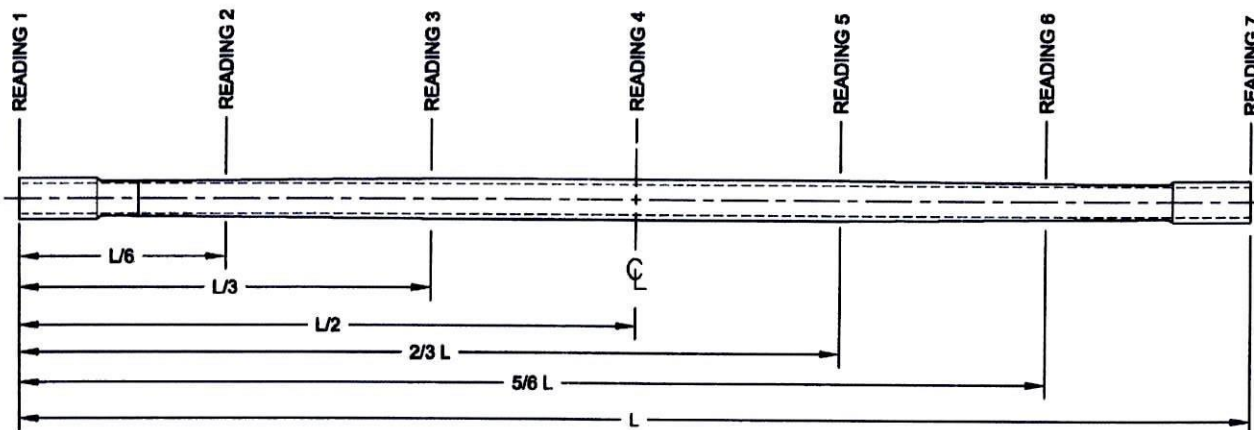
DART AEROSPACE LTD	Work Order: 174927
Description: Crosstube Assembly (AW119 MKII Fwd)	Part Number: D119-796-141TRN
Inspection Dwg: D119-796-141 Rev: H	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	6.00	+/-0.030	6.003	✓		VERNO8	
	2.516	+/-0.005	2.518	✓			
	2.333	+0.005/-0.000	2.338	✓			
	2.333	+0.005/-0.000	2.338	✓			
	2.408	+0.005/-0.000	2.413	✓			
	2.502	+0.005/-0.000	2.507	✓			
	2.596	+0.005/-0.000	2.601	✓			
	2.596	+0.005/-0.000	2.601	✓			
SIDE B	6.00	+/-0.030	5.996	✓			
	2.516	+/-0.005	2.5175	✓			
	2.333	+0.005/-0.000	2.338	✓			
	2.333	+0.005/-0.000	2.338	✓			
	2.408	+0.005/-0.000	2.413	✓			
	2.502	+0.005/-0.000	2.507	✓			
	2.596	+0.005/-0.000	2.601	✓			
	2.596	+0.005/-0.000	2.601	✓			
	102.26	+/-0.020	102.26	✓		TAPE	

DART AEROSPACE LTD	Work Order: 174927
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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	257	257	266	261	.009	0.030"
READING 2 L= 17.04	176	180	190	184	.014	
READING 3 L= 34.09	266	265 PMP	275	275	.010	0.063"
READING 4 L= 51.13	297	291	295	300	.009	
READING 5 L= 68.17	272	266	268	273	.006	
READING 6 L= 85.22	184	174	181	181	.017	0.030"
READING 7 L= 102.26	254	253	262	266	.013	

Calibration Result

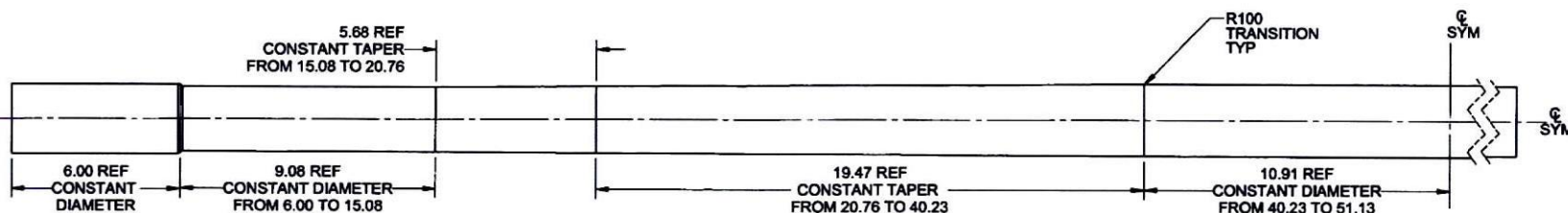
Actual Block Thickness: 100 - 300

Sitescan 250 Measured Thickness: 100 - 300

Measured by: DAS 56 9-89	Audited by: JW	Preliminary Approval:
Date: 2018-04-11	Date: 18-04-16	Date:

Rev	Date	Change	Revised by	Approved
A	15.04.14	New Issue (P/O D119-796-101)	KJ	
B	15.05.14	Tolerances revised per Dwg Rev G	KJ	
C	16.05.27	Dwg Rev updated	KJ	
D	16.09.13	Tolerance revised for Reading 3, 6 & 7	KJ	

MAR 27 2018



D119-796-141TRN CROSSTUBE, FWD

- 1) MATERIAL: MANUFACTURE FROM D6024-103 (PREFERRED) OR D6005-103
FINISHED LENGTH = 102.26 ±0.020 (BEFORE BENDING/TRIMMING)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 16.70 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

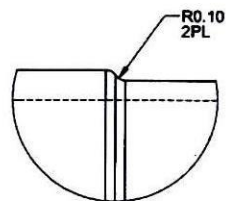
RELEASE
2015-11-01

ED
APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-141 TITLE XTUBE ASSY (AW119 MKII FWD) COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSE AND FOR THE CONSTRUCTION OF THE PARTS AND COMPONENTS ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR CONSTRUCTION OF THE PARTS AND COMPONENTS OTHER THAN THAT FOR WHICH IT WAS DESIGNED. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD.	REV. H
DRAWN	AP		SHEET 5 OF 6
CHECKED	AJS		SCALE
MFG. APPR.	JLM		NTS
APPROVED	WM		
DE APPR.	DS		
DATE 15.10.13			

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D119-796-141TRN CROSSTUBE, FWD
 SUPPLEMENTAL VIEW: NOMINAL WALL THICKNESS



DETAIL F
 SCALE 2X

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. H
MFG. APPR.	JLM	D119-796-141	SHEET 6 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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RELEASED
 2015-11-04

APPROVED

CHAMFER ID
 AS REQUIRED
 FOR TOOLING

F

6
 SYM

6
 SYM

0.258 REF
 NOMINAL WALL

0.167 REF
 NOMINAL WALL
 10.58±0.03

0.167 REF
 NOMINAL WALL
 15.08±0.03

0.204 REF
 NOMINAL WALL
 20.78±0.03

0.251 REF
 NOMINAL WALL
 30.49±0.03

0.298 REF
 NOMINAL WALL
 40.23±0.03

0.298 REF
 NOMINAL WALL
 51.13±0.03